

Work Order ID 68399

Tuesday, April 12, 2011 3:36:28 PM



PRELIMINARY ISSUE

Page 1

Item ID: D4366-041

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Fwd Wearplate Assembly

Start Date: 4/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00



Customer:



Reference:

Approvals:

Process Plan:

Date: 11-04-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4366	PA1								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4366-1)

Dwg Rev: PA1

Prog Rev: PA1

2-Deburr if necessary

SCRAP

B11-4-19

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-4-19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Tuesday, April 12, 2011 3:36:28 PM

Accept

[illegible]**Setup Start**

Stop

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Cust Item ID:**Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

**Insp.
Stamp**

0.00 - inspection to P21

Abstract

0.00 Day only

8 n 104/20 (H)

0.00

Abstract

0.00

Brake NC

SB 11/04/20

7

0.00 \rightarrow respects to Pa/

[illegible]

0.00 *Pen only*

5/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Item ID: D4366-041

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Item Name: Fwd Wearplate Assembly

Start Date: 4/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

0.00



Large Fab

Memo

0.00

Large Fab

1- on D4367-1, fill cut outs with hardcoat welding rod as per dwg D4366

DT9756

2059 B Hardcoat Welding Rod

BATCH#: _____

2-weld D4367-1 to wearplate by positioning holes together as per dwg D4366

304 S.S. Welding Rod

BATCH #: _____

3-Transfer drill holes in bar

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 11.11.13 AUTH u

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 68399

Tuesday, April 12, 2011 3:36:28 PM



Page 4

Item ID: D4366-041

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Fwd Wearplate Assembly

Start Date: 4/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

180



0.00

Small Fab

Memo

0.00

Small Fab

1- After finish, coat entire top (concave) surface as per note 10 on sheet 2 dwg
D4366.

190



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 68399

Page 5

Tuesday, April 12, 2011 3:36:28 PM

Item ID:	D4366-041	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Fwd Wearplate Assembly					
Start Date:	4/12/2011	Start Qty: 1.00		Cust Item ID:		
Required Date:	4/15/2011	Req'd Qty: 1.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

PD 2382

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, April 12, 2011 3:36:34 PM

Work Order ID: 68399



Parent Item: D4366-041



Parent Item Name: Fwd Wearplate Assembly

Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.12 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA		Purchased	No			100	sf	204.0000	2.13	2.242105			
-----------	--	-----------	----	--	--	-----	----	----------	------	----------	--	--	--



304/316 .050 Sheet



B11-4-19

Location

Loc Qty

Loc Code

MAT020

204

111743

1

112178

4

113062

18

116135

48

116604

37

116979

96

116135

①

D4367-1

Manufactured No

150

Each

0.0000

1

1



Bar

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

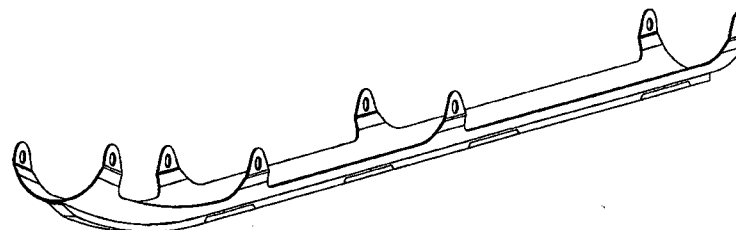
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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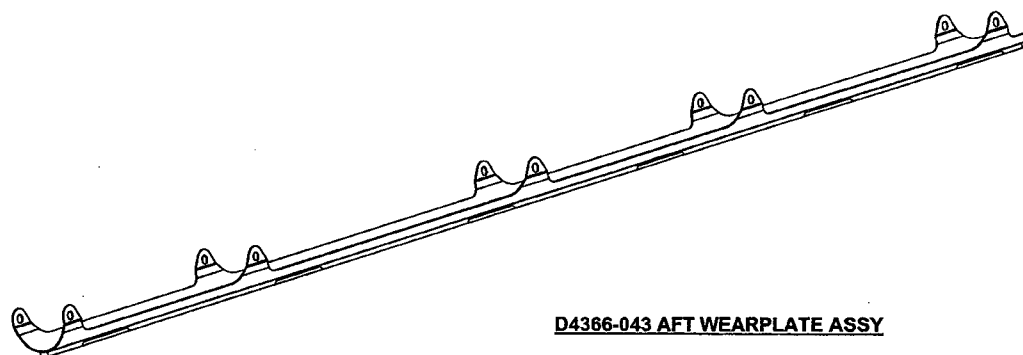
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X		D4366-041	FWD WEARPLATE ASSY
		X	D4366-043	AFT WEARPLATE ASSY
1	1		D4366-1	PLATE
2		1	D4366-3	PLATE
3	1		D4367-1	BAR
4		1	D4367-3	BAR
5	A/R	A/R	2059B	HARDCOAT
6	A/R	A/R	ROCKGUARD 4714	SEALANT



D4366-041 FWD WEARPLATE ASSY



D4366-043 AFT WEARPLATE ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68399

**PRELIMINARY
ISSUE**

PA1	NEW ISSUE	SC	11.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4366	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	11.03.24	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA INC.</small>	

8 7 6 5 4 3 2 1

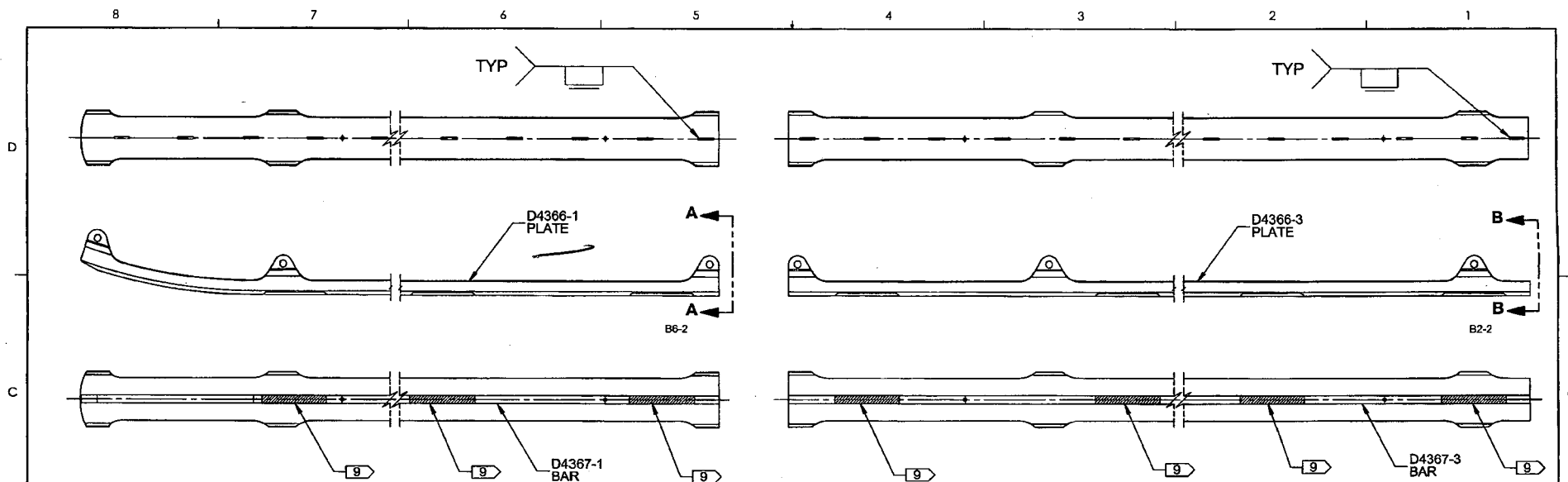
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

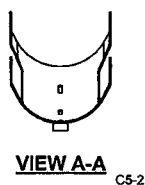
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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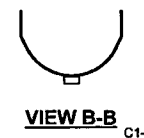


D4366-041 FWD WEARPLATE ASSY

D4366-043 AFT WEARPLATE ASSY



VIEW A-A
C5-2



VIEW B-B
C1-2

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4366-04X" PER QSI 044 6.1
- 7) WEIGHT: D4366-041 = 4.80 lbs; D4366-043 = 7.49 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4367-X BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR PROSEAL 1422 OR MIL-S-8802 CLASS B SEALANT OR PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4366	SHEET 2 OF 5
APPROVED		TITLE	SCALE
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**PRELIMINARY
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u/b 48379

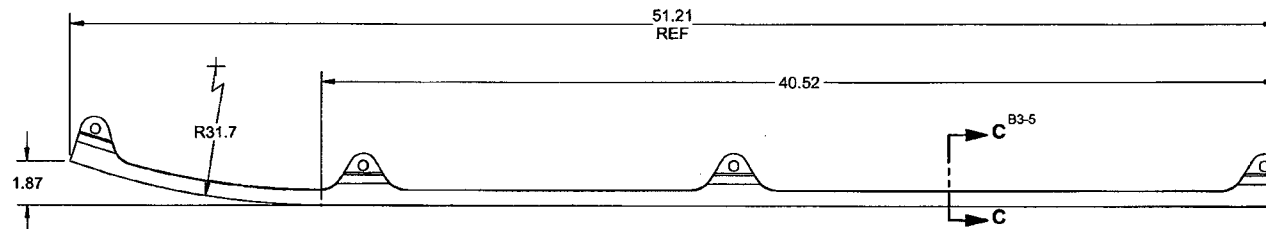
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

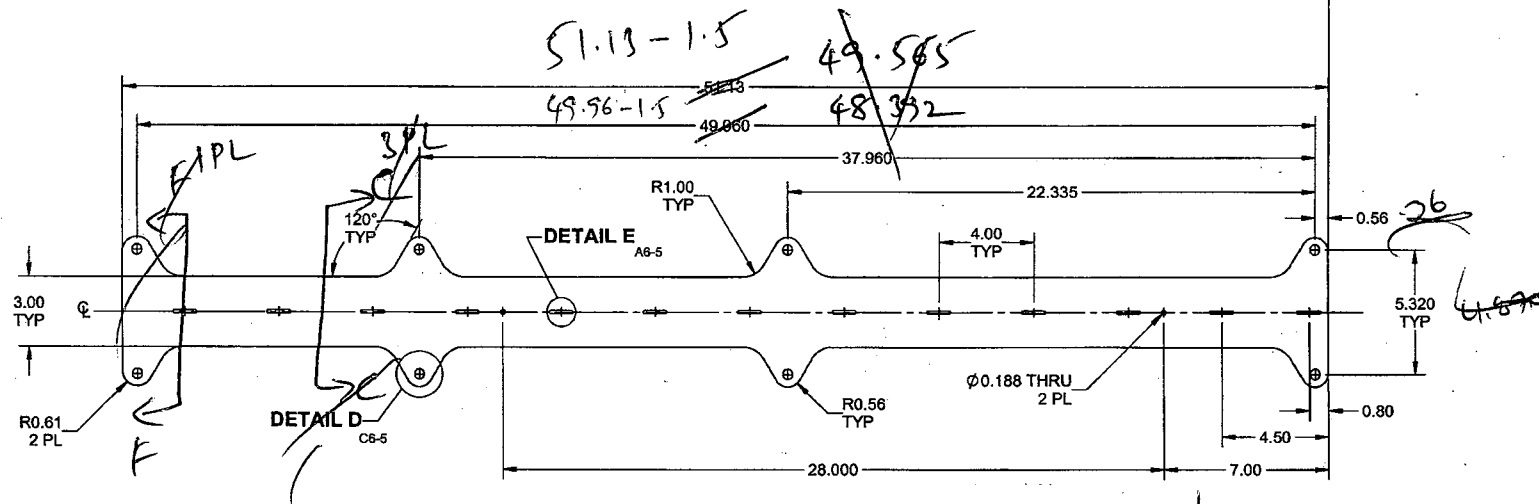
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4366-1 PLATE
(MAKE FROM D4366-1F)



D4366-1F PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.45 lbs

**PRELIMINARY
ISSUE**

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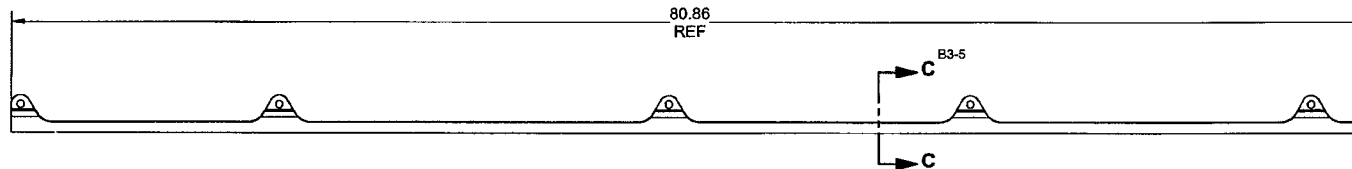
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

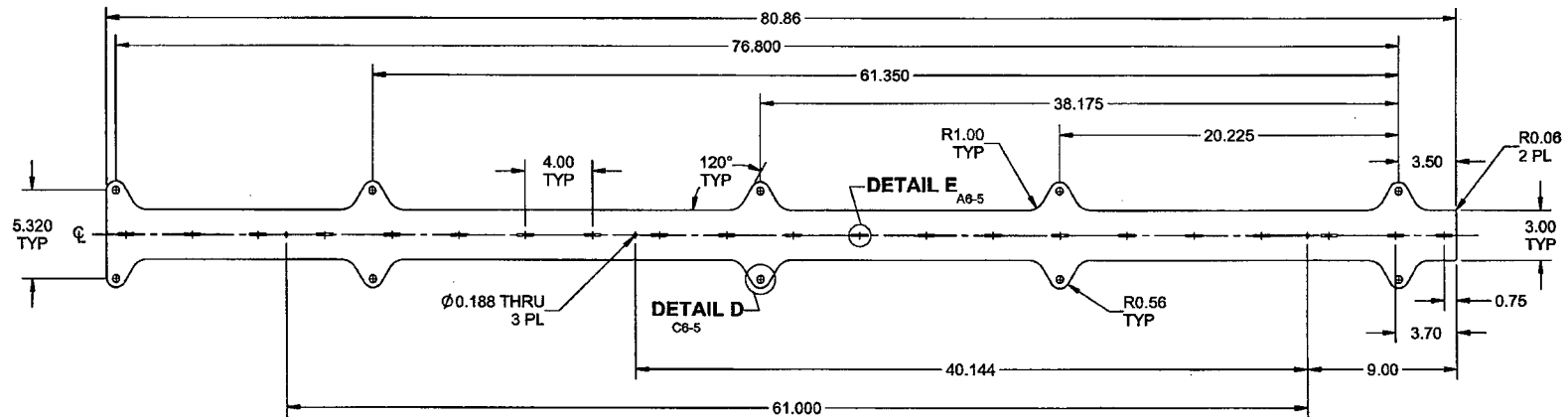
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4366-3 PLATE
(MAKE FROM D4366-3F)



D4366-3F PLATE

a/b 68399

**PRELIMINARY
ISSUE**

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.80 lbs

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	<i>JP</i>	DRAWING NO. D4366	REV. PA1 SHEET 4 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		WEARPLATE ASSY	NTS
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DATE	11.03.24		

8 7 6 5 4 3 2 1

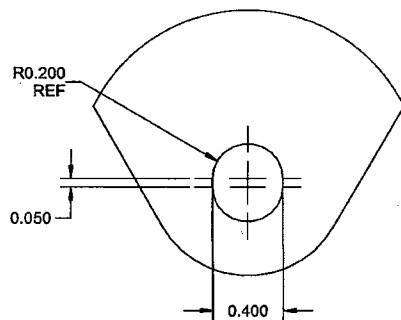
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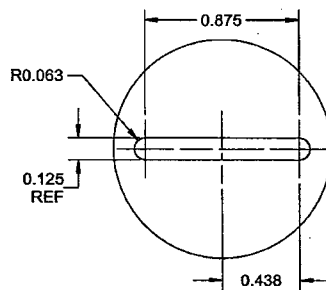
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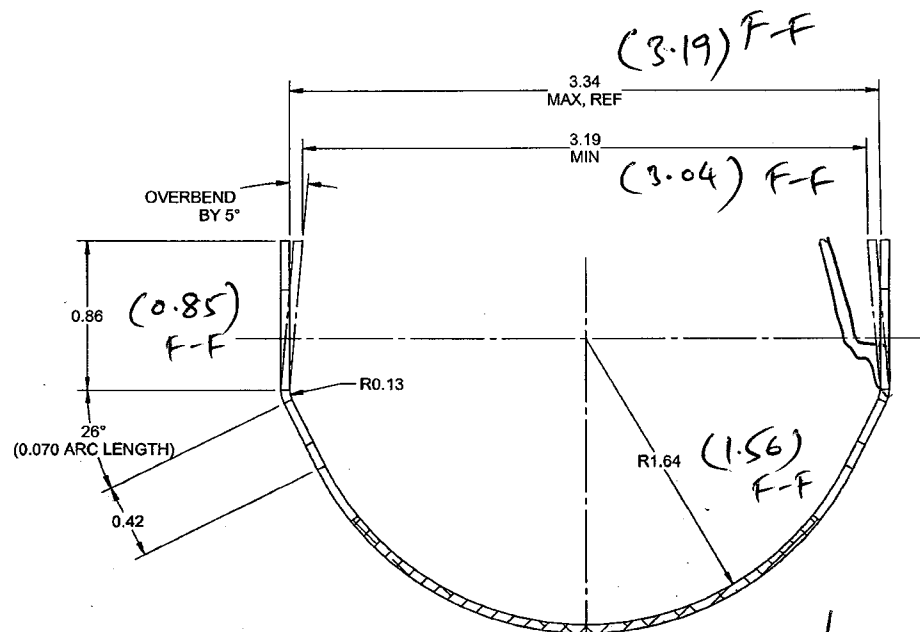
NOTE: Date & initial all entries



DETAIL D
SLOT DETAIL TYP
B6-3
B5-4



DETAIL E
SLOT DETAIL TYP
B5-3
B3-4



SECTION C-C
D2-3
D3-4

F-F

**PRELIMINARY
ISSUE**

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DRAWN	SC	PORT HADLOCK, WA	
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 68399
Description: FWD WEAR PLATE ASSEMBLY		Part Number: D4366-041
Inspection Dwg: D4366-1 Rev: PM		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.400	$\pm .010$.400	✓		U Bo2	
.125	$\pm .010$.126	✓		U	
.875	$\pm .010$.875	✓		U	
φ .188	$\pm .005$ - .001	.192	✓		U	
.56	$\pm .030$.558	✓		U	
.80	$\pm .030$.800	✓		U	
4.50	$\pm .030$	4.50	✓		U	
7.00	$\pm .030$	7.00	✓		U	
28.00	$\pm .030$	28.00	✓		T Bo1	
3.00	$\pm .030$	3.007	✓		U	
5.320	$\pm .010$	5.315	✓		T	
4.00	$\pm .030$	4.000	✓		U	
22.335	$\pm .010$	22.335			T	
37.960	$\pm .010$	37.960	✓		T	
49.960	$\pm .010$	49.960	✓		T	
51.13	$\pm .030$	51.13	✓		T	
10.50	$\pm .010$	10.46	✓		U	

Measured by: RB	Audited by: S	Prototype Approval:
Date: 11-4-19	Date: 11/04/20	Date:

Rev A	Date	Change New Issue	Revised by KJ/JLM	Approved
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